

Work Order ID 78238***78238***

Page 1

January-02-12 4:00:40 PM

Item ID: D2574

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Aft In 205

Start Date: 02/01/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 20/01/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: M.L.J.Date: 12/01/02 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2574 | Rev E | | | | | | | | |

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 78238 Double check by: SA 1-Machine Step
No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine
Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-
Machine Step No 3 per Folio FA051 and insp

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 78238

78238

Page 2

January-02-12 4:00:40 PM

Item ID: D2574 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Aft In 205
 Start Date: 02/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 20/01/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|-----------------|-----------------------------------|------|----|----------|--|--|--|--|--|
| 130 | QC8- Inspect parts - second check | 0.00 | SL | 12-01-31 | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

| | | | | | | | | | |
|----------------|---|------|--|--|--|--|--|--|--|
| 140 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |

| | | | | | | | | | |
|----------------|--|------|--|--|--|--|--|--|--|
| 150 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Powdercoat | Memo | 0.00 | | | | | | | |
| Powder Coating | | | | | | | | | |

START TIME: 2:30 OVEN TEMPERATURE:
 FINISH TIME: 3:00

m114480

3200F

3:00

(12)

12 BR 12-1-31.

12x4m/12/01/31

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 78238***78238***

Page 3

January-02-12 4:00:40 PM

Item ID: D2574 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Aft In 205
Start Date: 02/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 20/01/2012 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

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|-----|--------------------------|------|--|--|--|--|--|--|--|
| 160 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
|-----|--------------------------|------|--|--|--|--|--|--|--|

160

QC

Memo

0.00

Quality Control

12- BK 12-1-31

| | | | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|
| 170 | Identify as per dwg & Stock Location: 434 | 0.00 | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|

170

Packaging

Memo

0.00

Packaging

12/1/12

| | | | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|

180

QC

Memo

0.00

Quality Control

12/2/12

mf
12-02-01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

January-02-12 4:00:52 PM

Page 1

Work Order ID: 78238

78238

Parent Item: D2574

D2574

Parent Item Name: Saddle, Aft In 205

Start Date: 02/01/2012

Required Date: 20/01/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6101-005 | | Manufactured | No | | | 110 | Each | 56.0000 | 1 | 12 | | | |

D6101-005

Saddle Billet

**

B.A 12/01/24

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT041 | 51 | |
| 71721 | 1 | |
| → 76838 | 50 | |
| MAT045 | 1 | |
| → 74507 | 1 | |
| MAT046 | 4 | |
| 66966 | 3 | |
| 74507 | 1 | |

10.0

1.0

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | |
|---|---------------------------|
| DART AEROSPACE LTD | Work Order: 78238 |
| Description: Saddle, Aft Inboard | Part Number: D2574 |
| Inspection Dwg: D2574 Rev. E | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|--------|--------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.438 | 0.443 | | 0.438 | 0.438 | 0.438 | 0.438 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 8.001 | 8.001 | 8.001 | 8.001 | | |
| F | 0.490 | 0.510 | | 0.500 | 0.502 | 0.500 | 0.500 | | |
| G | 0.257 | 0.262 | | 0.259 | 0.259 | 0.259 | 0.259 | | |
| H | 0.375 | 0.380 | | 0.376 | 0.376 | 0.377 | 0.377 | | |
| I | 0.490 | 0.510 | | 0.500 | 0.500 | 0.500 | 0.498 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| K | 0.558 | 0.578 | | 0.568 | 0.568 | 0.568 | 0.566 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| M | 1.365 | 1.375 | | 1.370 | 1.370 | 1.370 | 1.370 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| O | 4.119 | 4.129 | | 4.124 | 4.124 | 4.124 | 4.124 | | |
| P | 0.115 | 0.135 | | 0.126 | 0.126 | 0.126 | 0.126 | | |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| R | 0.240 | 0.260 | | 0.250 | 0.248 | 0.248 | 0.249 | | |
| S | 0.115 | 0.135 | | 0.125 | 0.127 | 0.129 | 0.128 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 3.210 | 3.250 | | 3.230 | 3.230 | 3.230 | 3.230 | | |
| V | 0.230 | 0.250 | | 0.240 | 0.235 | 0.238 | 0.236 | | |
| W | 0.115 | 0.135 | | 0.126 | 0.125 | 0.125 | 0.125 | | |
| X | 0.307 | 0.312 | | 0.310 | 0.308 | 0.308 | 0.310 | | |
| Y | 0.760 | 0.765 | | 0.765 | 0.765 | 0.762 | 0.764 | | |
| Z | 0.352 | 0.372 | | 0.359 | 0.358 | 0.359 | 0.359 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.628 | 0.626 | 0.626 | 0.626 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.240 | 0.245 | 0.246 | 0.246 | | |
| AE | 1.500 | 1.520 | | 1.5134 | 1.5145 | 1.5105 | 1.511 | | |
| AF | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| AG | 0.240 | 0.280 | | 0.265 | 0.275 | 0.272 | 0.272 | | |
| AH | 0.240 | 0.260 | | 0.248 | 0.244 | 0.247 | 0.247 | | |
| AI | 2.000 | 2.020 | | 2.0045 | 2.006 | 2.003 | 2.003 | | |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.033 | 0.033 | | |
| Accept/Reject | | | | | | | | | |

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| Measured by: B.A. / ml 186 |
| Date: 12/01/25 |

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|----------------|
| Audited by: J |
| Date: 12-01-31 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.27 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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|---|---------------------------|
| DART AEROSPACE LTD | Work Order: 78238 |
| Description: Saddle, Aft Inboard | Part Number: D2574 |
| Inspection Dwg: D2574 Rev. E | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 15 | 16 | 17 | 18 | By | Date |
| A | 0.438 | 0.443 | | .438 | .438 | | | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 8.002 | 8.002 | 8.002 | 8.002 | | |
| F | 0.490 | 0.510 | | .500 | .500 | .500 | .500 | | |
| G | 0.257 | 0.262 | | .259 | .259 | .259 | .259 | | |
| H | 0.375 | 0.380 | | .377 | .377 | .377 | .377 | | |
| I | 0.490 | 0.510 | | .500 | .500 | .500 | .500 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| K | 0.558 | 0.578 | | .568 | .568 | .568 | .568 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| M | 1.365 | 1.375 | | 1.370 | 1.370 | 1.370 | 1.370 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| O | 4.119 | 4.129 | | 4.124 | 4.124 | 4.124 | 4.124 | | |
| P | 0.115 | 0.135 | | .126 | .126 | .126 | .126 | | |
| Q | 0.115 | 0.135 | | .135 | .135 | .135 | .135 | | |
| R | 0.240 | 0.260 | | .252 | .252 | .252 | .252 | | |
| S | 0.115 | 0.135 | | .128 | .128 | .128 | .128 | | |
| T | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | | |
| U | 3.210 | 3.250 | | 3.226 | 3.232 | 3.230 | 3.230 | | |
| V | 0.230 | 0.250 | | .240 | .243 | .243 | .243 | | |
| W | 0.115 | 0.135 | | .128 | .128 | .128 | .128 | | |
| X | 0.307 | 0.312 | | .308 | .308 | .308 | .308 | | |
| Y | 0.760 | 0.765 | | .763 | .763 | .763 | .763 | | |
| Z | 0.352 | 0.372 | | .367 | .367 | .367 | .367 | | |
| AA | 0.470 | 0.530 | | .500 | .500 | .500 | .500 | | |
| AB | 0.615 | 0.635 | | .629 | .629 | .629 | .629 | | |
| AC | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | | |
| AD | 0.240 | 0.260 | | .247 | .250 | .250 | .250 | | |
| AE | 1.500 | 1.520 | | 1.511 | 1.512 | 1.512 | 1.513 | | |
| AF | 0.115 | 0.135 | | .135 | .135 | .135 | .135 | | |
| AG | 0.240 | 0.280 | | .265 | .270 | .270 | .270 | | |
| AH | 0.240 | 0.260 | | .247 | .253 | .253 | .247 | | |
| AI | 2.000 | 2.020 | | 2.003 | 2.002 | 2.001 | 2.001 | | |
| AJ | 0.023 | 0.043 | | .033 | .033 | .033 | .033 | | |
| Accept/Reject | | | | | | | | | |

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|-----------------------------|
| Measured by: <i>SK 1/26</i> |
| Date: <i>12/01/96</i> |

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| Audited by: <i>SK</i> |
| Date: <i>12-01-31</i> |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|-----------|
| A | | New Issue | RF | |
| B | 02.09.27 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | <i>SK</i> |

| | | |
|---|--|---------------------------|
| DART AEROSPACE LTD | | Work Order: 78238 |
| Description: Saddle, Aft Inboard | | Part Number: D2574 |
| Inspection Dwg: D2574 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

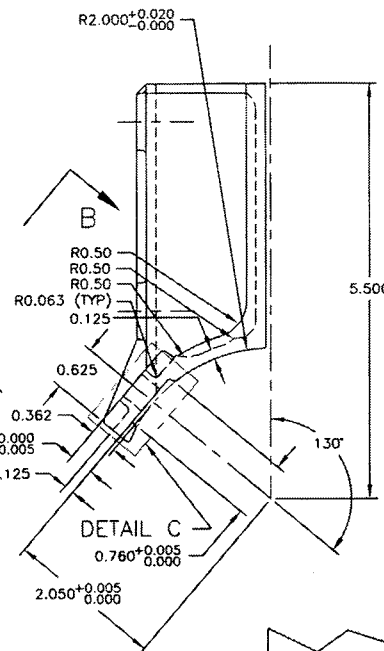
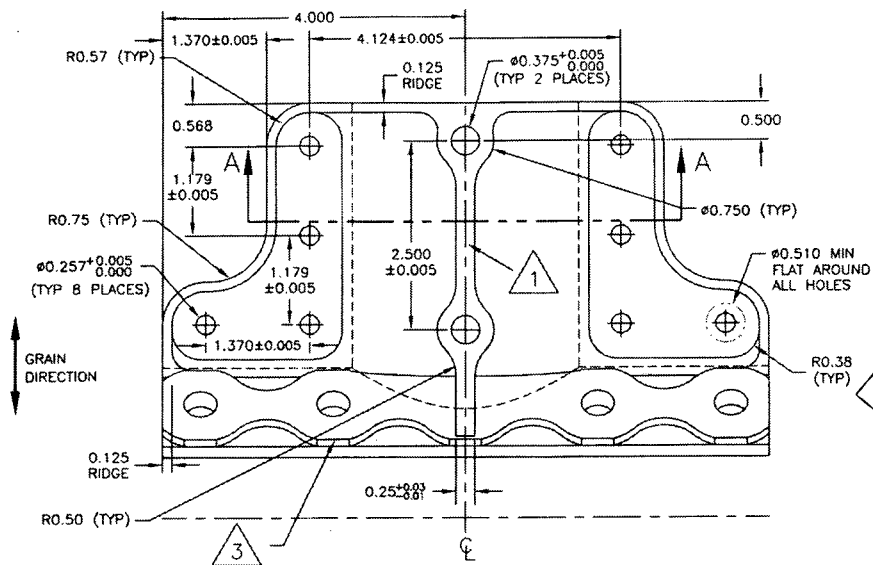
| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| | | | | #9 | #10 | #11 | #12 | | |
| A | 0.438 | 0.443 | | .438 | .438 | .438 | .438 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 8.002 | 8.002 | 8.002 | 8.002 | | |
| F | 0.490 | 0.510 | | .500 | .500 | .500 | .500 | | |
| G | 0.257 | 0.262 | | .259 | .259 | .259 | .259 | | |
| H | 0.375 | 0.380 | | .377 | .377 | .377 | .377 | | |
| I | 0.490 | 0.510 | | .500 | .500 | .500 | .500 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| K | 0.558 | 0.578 | | .568 | .568 | .568 | .568 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| M | 1.365 | 1.375 | | 1.370 | 1.370 | 1.370 | 1.370 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| O | 4.119 | 4.129 | | 4.124 | 4.124 | 4.124 | 4.124 | | |
| P | 0.115 | 0.135 | | .126 | .126 | .126 | .126 | | |
| Q | 0.115 | 0.135 | | .135 | .135 | .135 | .135 | | |
| R | 0.240 | 0.260 | | .252 | .252 | .252 | .252 | | |
| S | 0.115 | 0.135 | | .128 | .128 | .128 | .128 | | |
| T | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | | |
| U | 3.210 | 3.250 | | 3.226 | 3.226 | 3.226 | 3.226 | | |
| V | 0.230 | 0.250 | | .246 | .246 | .246 | .246 | | |
| W | 0.115 | 0.135 | | .128 | .128 | .128 | .128 | | |
| X | 0.307 | 0.312 | | .308 | .308 | .309 | .308 | | |
| Y | 0.760 | 0.765 | | .763 | .764 | .764 | .763 | | |
| Z | 0.352 | 0.372 | | .367 | .367 | .367 | .367 | | |
| AA | 0.470 | 0.530 | | .500 | .500 | .500 | .500 | | |
| AB | 0.615 | 0.635 | | .629 | .629 | .629 | .629 | | |
| AC | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | | |
| AD | 0.240 | 0.260 | | .247 | .247 | .247 | .247 | | |
| AE | 1.500 | 1.520 | | 1.511 | 1.511 | 1.511 | 1.511 | | |
| AF | 0.115 | 0.135 | | .135 | .135 | .135 | .135 | | |
| AG | 0.240 | 0.280 | | .265 | .265 | .265 | .265 | | |
| AH | 0.240 | 0.260 | | .249 | .249 | .249 | .249 | | |
| AI | 2.000 | 2.020 | | 2.003 | 2.003 | 2.003 | 2.003 | | |
| AJ | 0.023 | 0.043 | | .033 | .033 | .033 | .033 | | |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|----------|
| Measured by: | cmf |
| Date: | 12/01/31 |

| | |
|-------------|----------|
| Audited by: | Sh |
| Date: | 12-01-31 |





| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.27 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

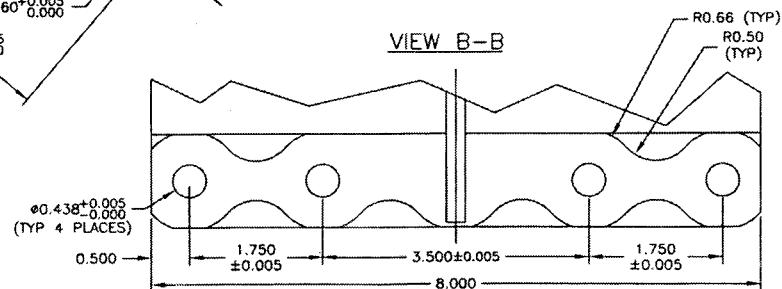
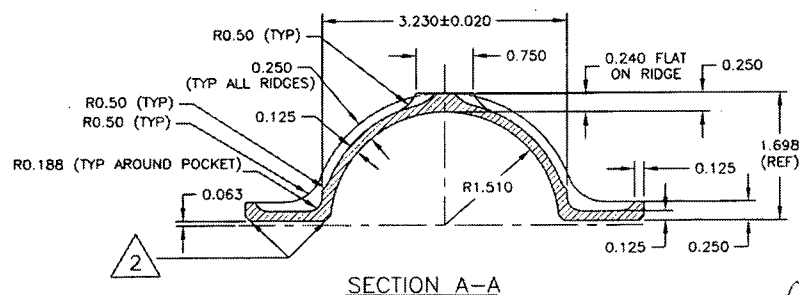
05.12.06



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063 x 45° ALL AROUND |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C) |




SECRET
UNCONTROLLED COPY
SUBJECT TO COMMENT
WHERE APPROPRIATE

DETAIL C
SCALE 2:1

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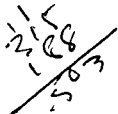
| | | |
|----------|----------|--|
| E | 05.07.13 | ADD CHAMFER ON RIDGE NOTE 4 |
| D | 02.09.06 | ADD RIDGES; TIGHTEN TOLERANCES |
| C | 99.10.22 | INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177 |
| B | 96.12.02 | ADD GRAIN DIR., 0.438 WAS 0.425 |
| A | 96.09.16 | NEW ISSUE |
| DESIGN | DRAWN BY |  DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA |
| DS | PH | |
| CHECKED | APPROVED | DRAWING NO. D2574 |
| DATE | | TITLE INNER AFT SADDLE |
| 05.07.13 | | |

WORK ORDER
NO. 78238 MLO
12/01/02

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|--|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | <div style="text-align: center;">  </div> | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries